

Date: Wednesday, 03/09/2008 10:34:51 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : LUG ASSEMBLY |
| Job Number | : 41763 | | |
| Estimate Number | : 10911 | | |
| P.O. Number | : | Part Number | : D3405041 |
| This Issue | : 03/09/2008 S.O. No. : | Drawing Number | : D3405 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : LARGE FAB ASSY | Drawing Revision | : A |
| Previous Run | : 35779 | Material | : |
| Written By | : | Due Date | : 20/09/2008 Qty: 20 Um: Each |
| Checked & Approved By | : <u>JUD 08.9.03</u> | | |
| Comment | : Est A 05.09.01 New issue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S11GA | 304/316 0.125 Sheet |
|-----|-----------|---------------------|



Comment: Qty.: 0.1617 sf(s)/Unit Total : 3.2340 sf(s)
 304/316 .125 Sheet
 (M304S11GA)
 Batch: 108156 HB 8-9-4

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3405
 Dwg Rev: A
 Prog Rev: A

HB 8-9-4(30)

2-Deburr if necessary

HB 8-9-4

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

508/02/04 counter
(430)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Deburr
 Form using DT8204 as per Dwg D3405

EP 08/10/09SA 08/10/20(30)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:34:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 41763

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/20 *counter* *(X30)*

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

B37061

A/R

SS Rod

M106115

EL

8-10-28

X30

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

EL

8-10-28

X30

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/29 *(30)*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/30 *counter* *(X30)*

11.0

POWDER COATING

POWDER COATING



M 109152



(30X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
01
4:00
2:30

M-1

08/10/30

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EL *08/10/30* *(30)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:34:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 41763

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST470

10/31

(30)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

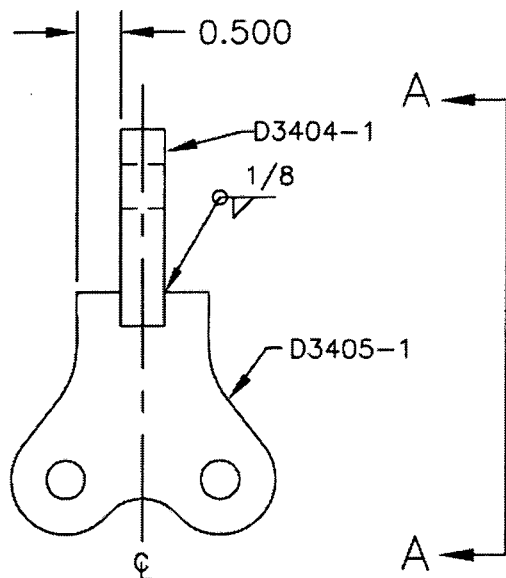
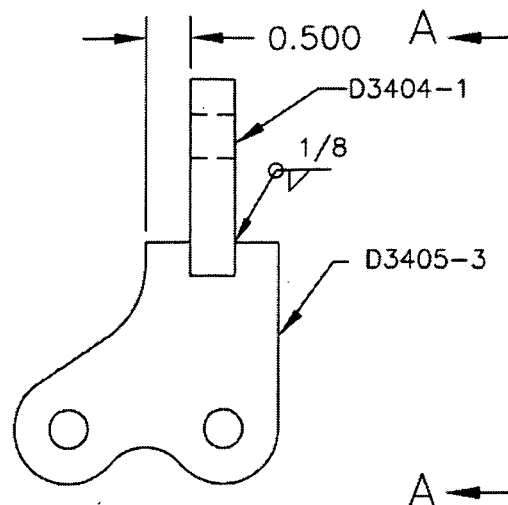
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

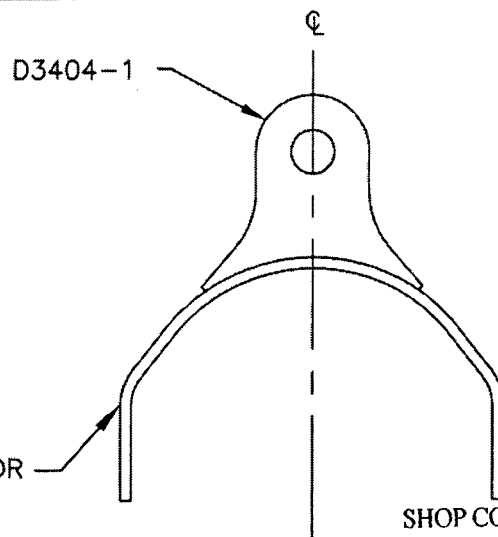
| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3405 | REV. A SHEET 1 OF 2 |
| DATE 05.03.08 | | TITLE GHW LUG ASSEMBLY | SCALE 1:2 |
| A | 05.03.08 | NEW ISSUE | |

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

| QTY - 041 | QTY - 043 | PART NUMBER | DESCRIPTION |
|--------------|--------------|-------------|--------------|
| X | | D3405-041 | LUG ASSEMBLY |
| | X | D3405-043 | LUG ASSEMBLY |
| 1 | 1 | D3404-1 | GHW LUG |
| 1 | | D3405-1 | GHW BRACKET |
| | 1 | D3405-3 | GHW BRACKET |

RELEASED
05 08 09**D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

**VIEW A-A**

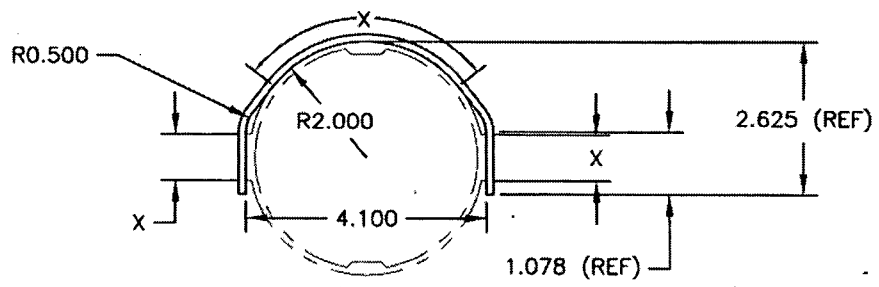
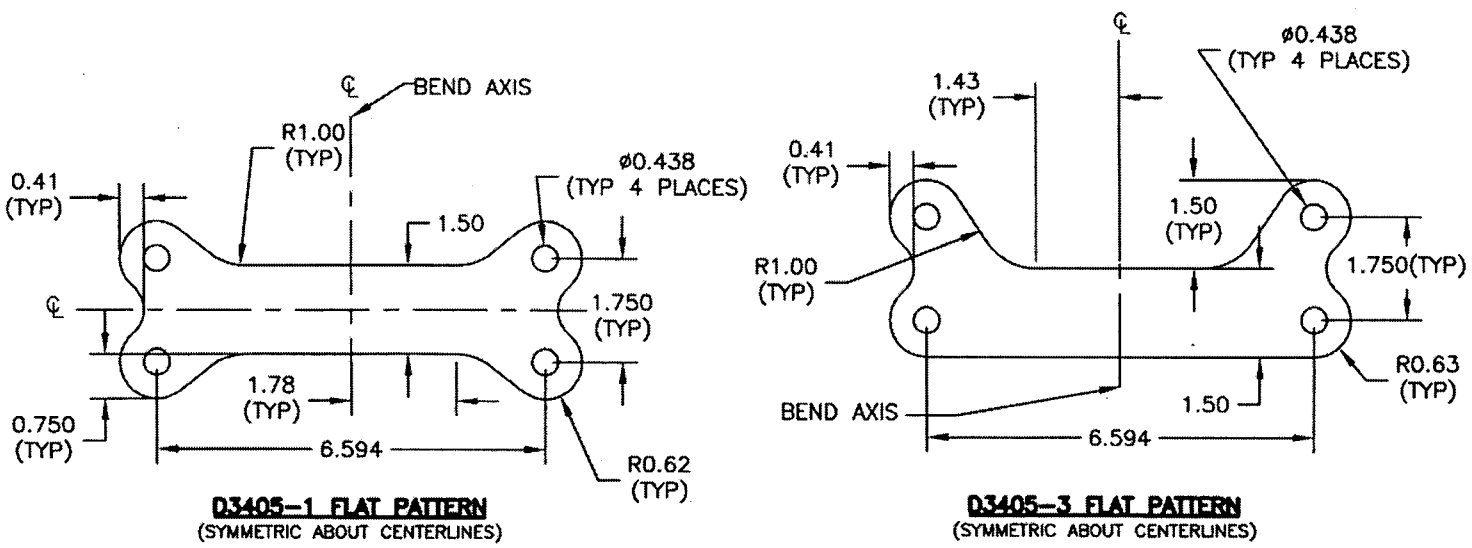
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41763

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DART

| | | | | |
|---------|--------------------|-------------|--------------------|---------------------------------|
| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | PORT HADLOCK, WA |
| DATE | 05.03.08 | DRAWING NO. | D3405 | REV. A |
| | | TITLE | CHW LUG ASSEMBLY | SHEET 2 OF 2 |
| | | | | SCALE 1:3 |



D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

RELEASED
05-08-04

- SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
- NO. 41763
- CHW BRACKET
- MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- FINISH: NONE
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4)

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